Ship Apr

## \*99443\*

Page 1

Revision ID:	D2970-1 Wearplate			Accept	*N900	)040	100	<b>)*</b>	Setup Sta	i Vi	S1* S2*
Start Date: Required Date: Reference:		tart Qty: 8.00 eq'd Qty: 8.00	*8* *8*		Cust Item Customer						
Approvals:		• •	Date:\3-64-09 Date:			Date:	- :	F	Run Sta Sto	1/1	R1* R2*
Sequence ID/ Work Center ID	•	peration scription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	n Nbr									······································
D2970	В										•
*100 *100* Waterjet FLOW CNC Waterjet		OW WATER JET  Memo	D D2070	0.00				Ja.	<u></u>		Jm13-4-9
304 + 040	ι	Dwg Rev:_ Prog Rev:_ 2-Deburr if	B								* *
110	QC	2- Inspect parts off m	achine FAI/FAIB	0.00							
*110* QC Quality Control		Memo		0.00				183	٥		Jm34-0

												DQA:	Da	te:	
NCR:	⁄es	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE					·
					-						(	QA Closed:	Da	te:	
Work Orde	or.			,		DISPOSITION				AGAINST DE	EP.	ARTMENT/	PROCESS		
WOIN OIG		<del></del>				Rework	1		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part N	No.				:	Scrap		i	Machining	Small Fab		Prod	d. Eng. Coor.		Quality
	•					Use-as-is		Thern	noforming	Finishing	]	Rec/Stor	e/Packaging	-	Other
NCR N	۱o	*				Work Order Update	]		Large Fab	Composite	_		Supplier	Ш	
Root		'			Descri	ption of work order update		Initial	Ac	ction	Ţ	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	cription	1	Date	Verification	<u>n</u>	QC Inspector
Doc/Data	Ц						1		-					i	
Equip/Tooling	Ц						1							1	
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Process			İ										•		
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Training	Ц														
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Landi					_	General	_	7		_	_		i	г	1
	-	Bending				Bend	<u>_</u>	Grain		<u> </u>	-	Ovalized		<u>—</u>	Pressure/Forced
	$\boldsymbol{\vdash}$	Centre No	ot Concer	ntric to	o/s	BOM/Route	_	Hardwa			-	Over/Under			Temperature/Cure
	<b>├</b>	Cracks				Broken/Damaged		4 '	on Incomplete	`	┥.	Part Incorrec		<u> </u>	Weld .
·       •	_	Crushed/	Crimped		<u> </u>	Burrs	<u></u>	4	ions Incomplete/	/Unclear	┥.	Part Lost/Mis	ssing		Wrong Stock Pulled
	$\boldsymbol{\vdash}$	Cuffs				Contamination	1	Mainte				Part Moved			
	-	Heat Trea				Countersink	$\perp$	Mislabe		_	_	Positioned W	- 1		1
	╚	Inspectio	n Strip in	Tube		Cut Too Short	L	Misread	d		F	Power Loss/S	Surge		Other
	1 1	Rinnles in	Bend		1	Drill Holes	1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

Memo

Page 2 April-09-13 8:32:21 AM Item ID: D2970-1 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Wearplate Start Date: 4/09/13 Start Oty: 8.00 **Cust Item ID:** Required Date: 4/15/13 Req'd Oty: 8.00 **Customer:** Reference: Run Start Process Plan: Date: Tooling: Approvals: Date: Stop QC: \_\_\_\_ Date:\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Accept Reject Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp 120 QC8- Inspect parts - second check 0.00 \*120\* 0.00 Memo Quality Control 130-0.00 NC BRAKE \*120\* Brake NC 0.00 Memo Brake NC Deburr and form on brake using DT8178 and DT8261as per Dwg D2970 140 QC5- Inspect part completeness to step on W/O \*140\*

												DQA:	Date:	
NCR:	es ,	No No				WORK ORDER NON-C	100	NFORI	MANCE / UP	PDATE		QA Closed:	Date:	
						DISDOSITION				A.C.A.U	NCT DE		r	
Work Orde	er:					DISPOSITION				AGAII	131 DE	PARTMENT,	/PROCESS	
Part N	— 					Rework Scrap Use-as-is			Skid-tube Machining	Crosste Small Finish	Fab	•	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No					Work Order Update			Large Fab	Compo			Supplier	
Root		4			Descri	ption of work order update	1	nitial	Ad	ction		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	QC Inspector
Doc/Data							1			·		,		·
Equip/Tooling														
Operator							l						•	
Material									-					
Setup														
Other -				ļ										
Process		-					1						·	
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Unapproved	П	*											·	
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Landi	ng Ge	ar				General		_						_
	. В	ending				Bend		Grain	•			Ovalized		Pressure/Forced
		entre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance	Temperature/Cure
	C	racks		· 9.		Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct	Weld
:		rushed/	Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	· [	Part Lost/Mi	ssing	Wrong Stock Pulled
	$\Box$ c	uffs				Contamination		Mainte	nance			Part Moved		
	Πн	eat Trea	it	-		Countersink	Г	Mislabe	eled			Positioned V	Vrong	•
	$\square$ "	spectio	n Strip in	Tube		Cut Too Short		Misread	i			Power Loss/	Surge	Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

\*170\* Packaging

Packaging

Page 3 April-09-13 8:32:21 AM Item ID: D2970-1 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Wearplate **Start Date:** 4/09/13 Start Qty: 8.00 Cust Item 1D: Required Date: 4/15/13 Req'd Qty: 8.00 **Customer:** Reference: Run Date: Approvals: **Process Plan:** Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description Run Hours Code Qty Qty Number Stamp 150 0.00 \*150\* HandFinish 0.00 Hand Finishing Coat entire top concave surface with a layer or rockguard as per dwg A/R Rockguard batch: 125226 160 QC3- Inspect Part Finish 0.00 \*160\* QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: [-10-607] 170

0.00

Memo

											DQA:	Da <sup>-</sup>	te: _	
NCR: Y	⁄es	/ No				WORK ORDER NON-C	ON	IFORN	MANCE / UP	DATE	QA Closed:	Da	to·	
•						DISPOSITION				AGAINST DE				
Work Orde	er:					ļ	. 1			<u> </u>	7			
Part N	١٥.					Rework Scrap Use-as-is		ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	No.					Work Order Update			Large Fab	Composite	]	Supplier	$\overline{}$	
Root					Descri	ption of work order update	Ir	nitial	Act	tion	Sign &			
Cause	$\Box$	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training														
Unapproved				ļ										
						F/	AUL	T CATE	GORY					
Landi	ng (	ear				General				<b></b>	7	1		
	$\vdash$	Bending				Bend	$\vdash$	Grain			Ovalized		-	Pressure/Forced
	Ь	Centre No	ot Concer	ntric to	o/s	BOM/Route	-	Hardwa			Over/Under			Temperature/Cure
	$\vdash$	Cracks			-	Broken/Damaged	$\vdash$		on Incomplete	<u> </u>	Part Incorred		-	Weld
	-	Crushed/	Crimped		<u> </u>	Burrs	-		ions Incomplete/	Unclear	Part Lost/Mi	ssing	LLJ	Wrong Stock Pulled
		Cuffs				Contamination	_	Mainte		<u> </u>	Part Moved			
		Heat Trea				Countersink	$\boldsymbol{\vdash}$	Mislabe		<u> </u>	Positioned V	-		
	_	Inspectio		Tube		Cut Too Short	-	Misread	d	L_	Power Loss/	Surge	Ш	Other
	1	Ripples in	Bend		1	Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Page 4

April-09-13 8:2	32:21 AM			992	+44.7		•			rage 4
Item ID: Revision ID: Item Name:	D2970-1 Wearplate			Accept	*N900	04010	<b>N</b> *		Start *NS1 Stop *NS2	_
Start Date: Required Date: Reference:	4/09/13 : 4/15/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item   Customer:					
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ate:ate:			Start *NR′ Stop *NR′	
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accep Qty	t Rejec Qty	ct Reject Ins	-
*180* QC		Мето		0.00				13/1	1159	

N13-04-12

					DQA:	Date:	
NCR: Yes /	No	<b>WORK ORDER NON-CO</b>	NFORMANCE / UPI	DATE			
				(	QA Closed:	Date:	
Work Order:		DISPOSITION		AGAINST DEP	ARTMENT/PR	ROCESS	
		Rework	Skid-tube	Crosstube		Water Jet	Engineering
Part No.		Scrap	Machining	Small Fab	Prod. 8	ing. Coor.	Quality
	·	Use-as-is	Thermoforming	Finishing	Rec/Store/I	Packaging	Other
NCR No.		Work Order Update	Large Fab	Composite		Supplier	

Root				Descrip	tion of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty	o	r Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data						1						
Equip/Tooling						1						
Operator							i					
Material												
Setup												
Other			1									
Process											:	
Supplier												
Training												
Unapproved '												
					F	AUL	T CATE	GORY				
Landing	Gear				General		_		_	-		7
	Bending				Bend		Grain		L	Ovalized	<u>_</u>	Pressure/Forced
	Centre No	ot Concer	ntric to C	D/S	BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	it	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance	L	Part Moved		
	Heat Trea	it			Countersink		Mislabe	led	L	Positioned V	Vrong	_
	Inspection	n Strip in	Tube		Cut Too Short		Misread	1	L	Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		Offset					
	Torque W	aves in E	xtrusion	ո [	Drawing		Out of C	Calibration				·
	Turning S	equence			Finish		Out of S	equence			· · ·	
	Wave/Tw	ist in Tub	oe		Folio		Outside	Dimensions		··-		

## **Picklist Print**

April-09-13 8:32:24 AM

Work Order ID: 99443

\*99443\*

Parent Item:

D2970-1

\*D2970-1\*

Parent Item Name: Wearplate

**Start Date:** 4/09/13

Required Date: 4/15/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: B01.06.07Added Material and Tool number SM/EC

IPP Rev:C Now on Waterjet 07-06-27 JLM

13.04.08 AS PER DWG REV.B DD VERF:JLM

IPP REV:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	386.6500	0.365	3 <del>.073</del> 684	•		*
*M304S20 304/316 .040 Sheet	NGA*								**	3.5			Jm13-4-9

<b>Location</b>	Loc Qty	Loc Code	
MAT020	386.65		
124029	117.15		·
124956	269.5		124956

				MODE ODDED A	ION COL	NEODA	AANCE / UD	DATE	DQA:	Date:	<b>.</b>
NCR: Yes	/ No			WORK ORDER N	IOIN-COI	NFORI	VIANCE / UP		QA Closed:	Date:	
Work Order:				DISPOSITION	1			AGAINST DE	PARTMENT	/PROCESS	
Part No.				Rew Sc Use-a Work Order Upd	rap s-is	Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	Description of work order up or Non-conformance		Initial nief Eng		tion cription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling											

## Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Grain Ovalized Bending Bend Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S BOM/Route Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Part Moved Cuffs Contamination Maintenance Positioned Wrong Heat Treat Countersink Mislabeled Other Power Loss/Surge Inspection Strip in Tube **Cut Too Short** Misread Offset Ripples in Bend **Drill Holes** Drawing Out of Calibration Torque Waves in Extrusion Turning Sequence Finish Out of Sequence Folio **Outside Dimensions** Wave/Twist in Tube

Operator Material

DART AEROSPACE LTD	Work Order:	99443
Description: Wearplate	Part Number:	D2970-1
Inspection Dwg: D2970 Rev: Rev		Page 1 of 1

## 13/04/09 FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.220 x 0.300	+/-0.010	6227 x030			J	Jemon
2.063	+/-0.010	7.065"	J		V	
2.813	+/-0.010	2.810"	~		V	
5.800	+/-0.010	5.801	-		V	
0.375	+/-0.010	0.374			T	JKN06
55.000	+/-0:010					
0.040	+/-0.010	0.035"	_		V	
17.400"	+1-0010"	17,400	_		T	
					***************************************	

Measured by:	Audited by:	40	Prototype Approval:	N/A
Date: 134-9	Date:	13.49	Date:	N/A

Rev	Date	Change	 Revised by	Approved
A	08.11.27	New Issue	KJ/EC	1
			<del></del>	



